

THIS DRAWING IS THE EXCLUSIVE PROPERTY OF ISRO AND SHALL NOT BE COPIED, REPRODUCED OR COMMUNICATED TO OTHERS WITHOUT PROPER AUTHORISATION

CC RELEASE	
CHD.	
APPD.	

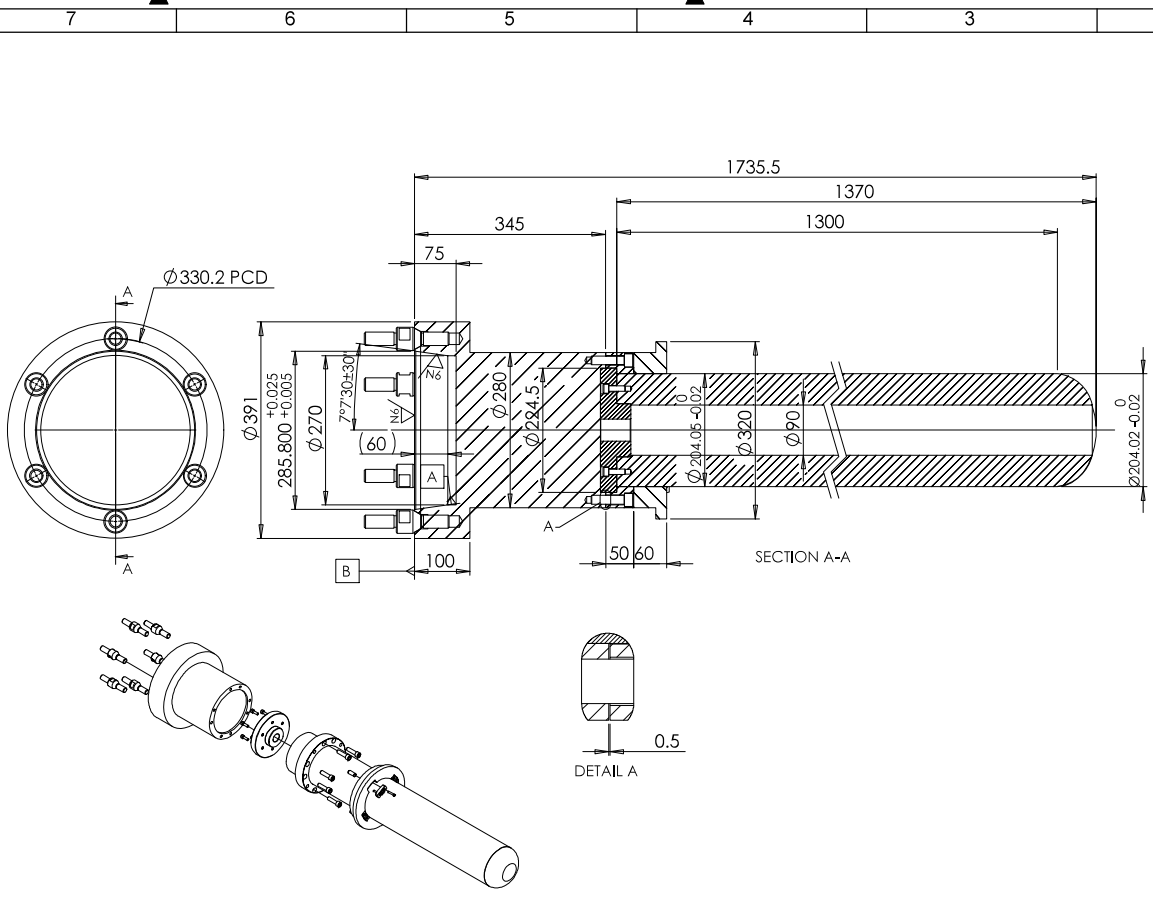
8 7 6 5 4 3 2 1

LENGTH OR DIA	UPTO 6	± 0.1
	6	± 0.2
30	120	± 0.3
	120	± 0.5
315	1000	± 0.8
	1000	± 1.2
2000	4000	± 2.0
	4000	± 3.0
UPTO 6	6-30	± 1°
	30-120	± 20'
LENGTH IN mm OF SHORTER SIDE OF ANGLE	120-400	± 10'
	4000	

DO NOT SCALE THE DRAWING
 ASK IF IN DOUBT
 UNLESS OTHERWISE SHOWN
 ALL DIMENSIONS ARE IN MILLIMETERS
 REMOVE SHARP EDGES AND BURRS
 CHAMFER 1mm X 45°
 MACHINING FINISH IN MICRONS

▽ 8-25 ▽ 1.6-8

▽▽ 0.025-1.6 ▽▽▽ < 0.025



- NOTE:**
- BREAK THE SHARP EDGES WITH 0.2 x 45° OR R0.2 MAX.
 - CHROME PLATING SHOULD BE DONE TO 10 ~ 15 MICRONS.
 - MACHINED SURFACE SHOULD BE "N6" SURFACE FINISH.
 - ALL THE DIMENSIONS AFTER PLATING ONLY.
 - THE COMPONENT SHOULD BE HARDENED TO HAVE 58 ~ 60 HRC.

REV.No.	ZONE	SIGN	DATE

ITEM No.	DESCRIPTION	MATERIAL	QTY.	WT.	REMARKS
MATERIAL					No.OFF 01
TITLE					
Mandrel Assembly					WT.Kg
DGN. AKJ 10.05.24 DRN. TRD. CHD. AKJ 10.05.24 APPD.					
GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION VIKRAM SARABHAI SPACE CENTRE THIRUVANANTHAPURAM					GROUP / PROJECT RMFD/EFA
DRG.No. RMFD/FF/MANDREL/23/10 SCALE					R0 SHEET 1 OF 1

REVISIONS ASSEMBLY DRG.

F E D C B